

Date: Wednesday, 1/18/2006 4:04:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 25554					
Estimate Number	: 10255					
P.O. Number	: N/A		Part Number	: D22301		
This Issue	: 1/18/2006	S.O. No. : N/A	Drawing Number	: D2230 REV F		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A	Type : MACHINED PARTS	Drawing Revision	: F		
Previous Run	: 25553		Material	: N/A		
Written By	<u>SEE COMMENT BELOW</u>		Due Date	: 2/15/2006 Qty: 200, Um: Each		
Checked & Approved By						
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s) Lug Extrusion D2423 Extrusion Batch: <u>B23779</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: <u>B23779</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per lotto D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling		
<i>Issue P-O</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC3	SECOND CHECK
Comment: SECOND CHECK <u>Inspect Level 5</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 25554

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-20-02 / 5A1

06-02-20

7.0 QC5

INSPECT WORK TO CURRENT STEP



06-02-20

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

DC 06/02/25 203

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

St 370

DC 06/12/27 146303

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/03/01

Job Completion



U 06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

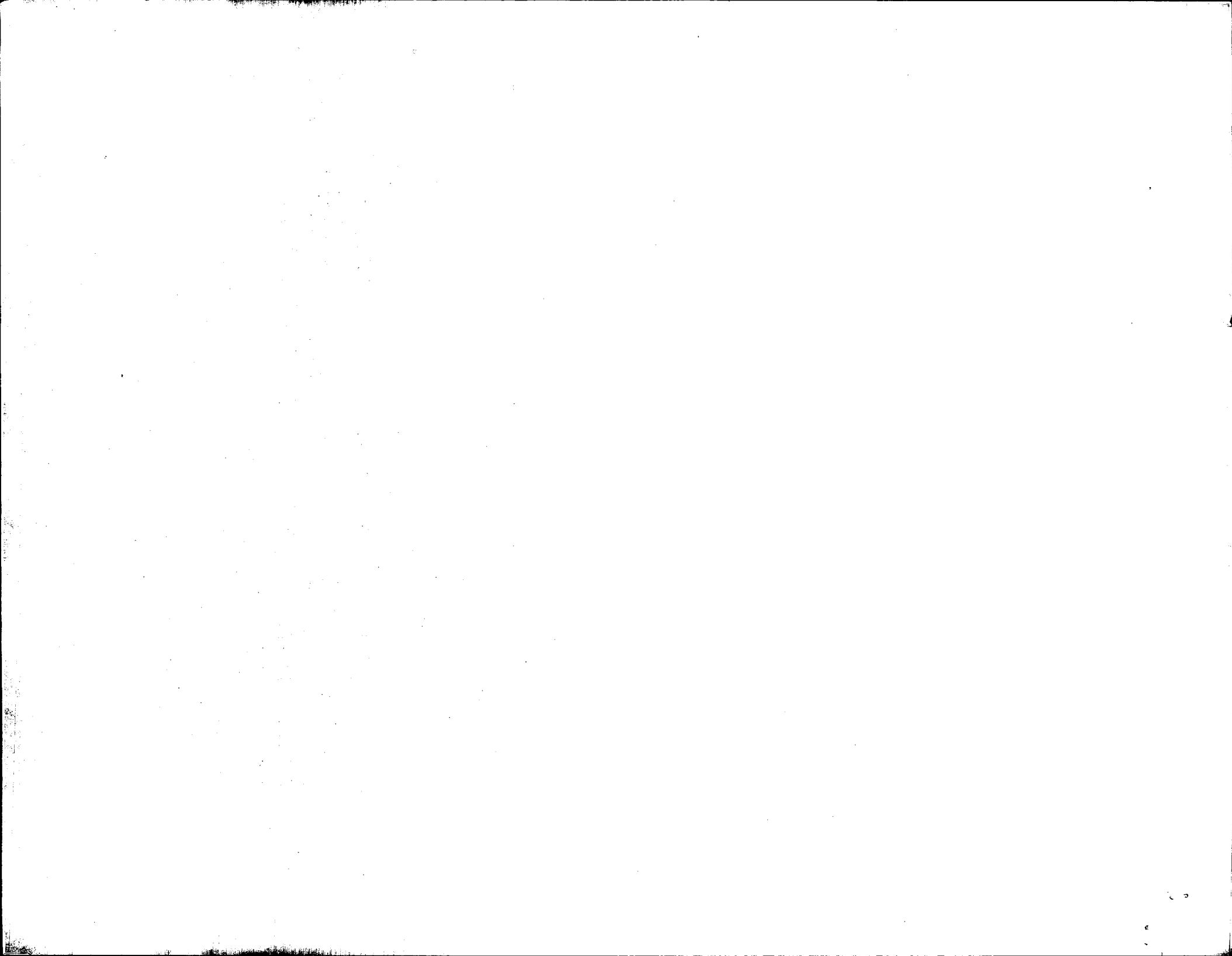
DART AEROSPACE LTD	Work Order:	25554
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	

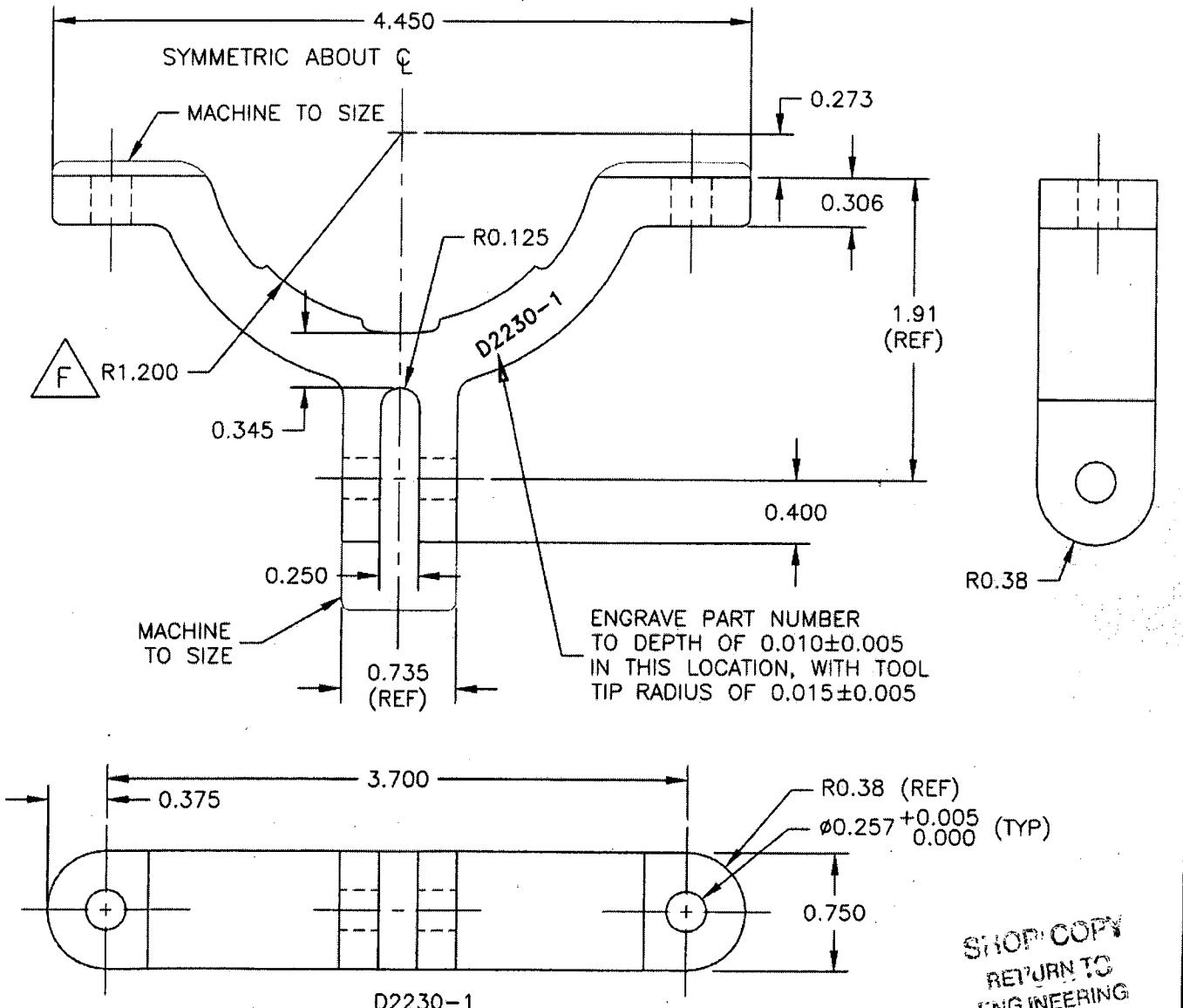


DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		TITLE MOUNTING LUG
		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
INJECT TO AN
MFG
W/ J
25554

DART

DESIGN	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO. D2230
DATE		99.12.13	TITLE MOUNTING LUG

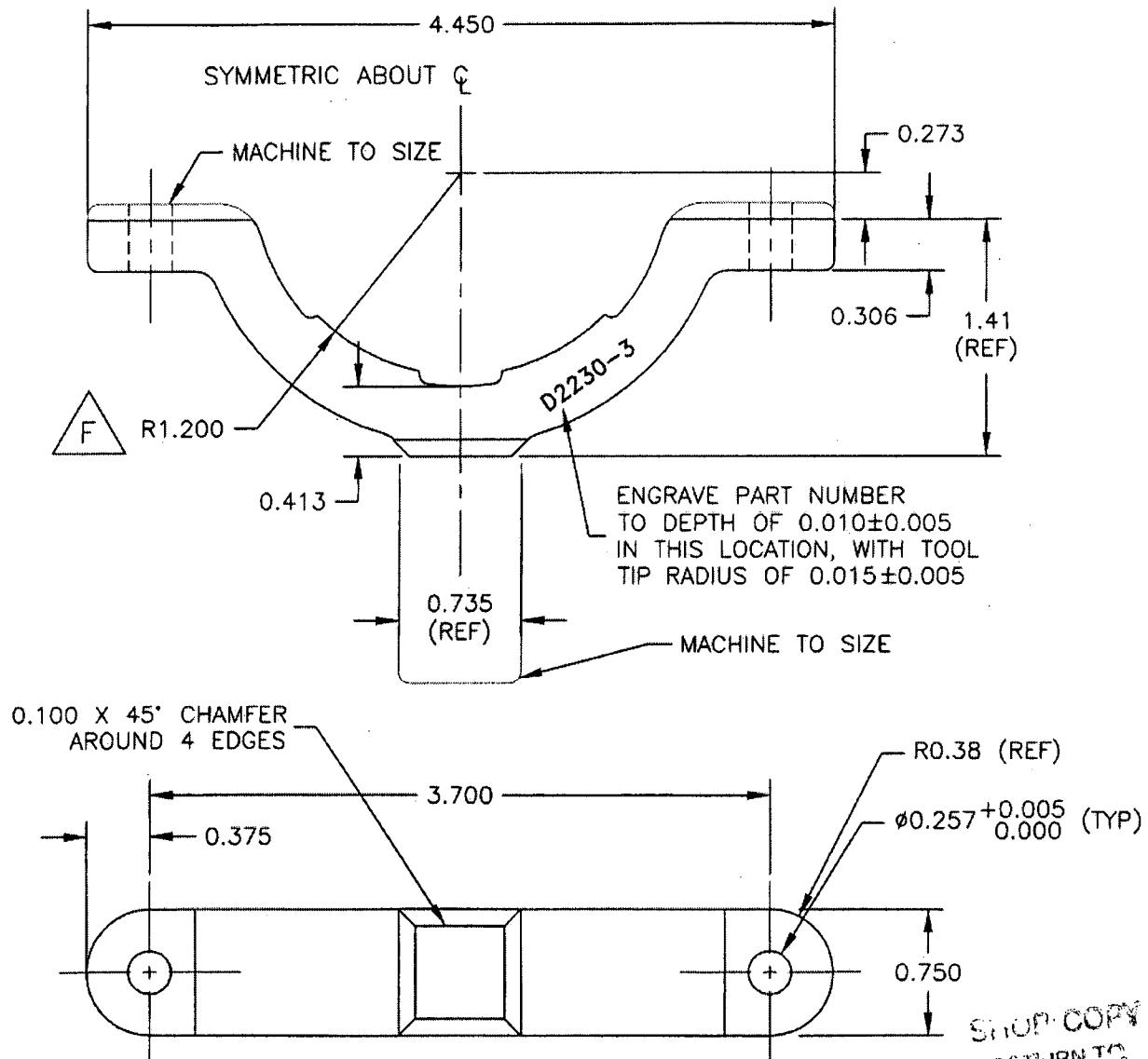
REV. F

SHEET 2 OF 2

1:1

RELEASED

99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDERS

25554



**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

200

PART NUMBER

D2230-1

PART NAME

Mounting Lug

P.O. NUMBER

446

MATERIAL supplied by DART

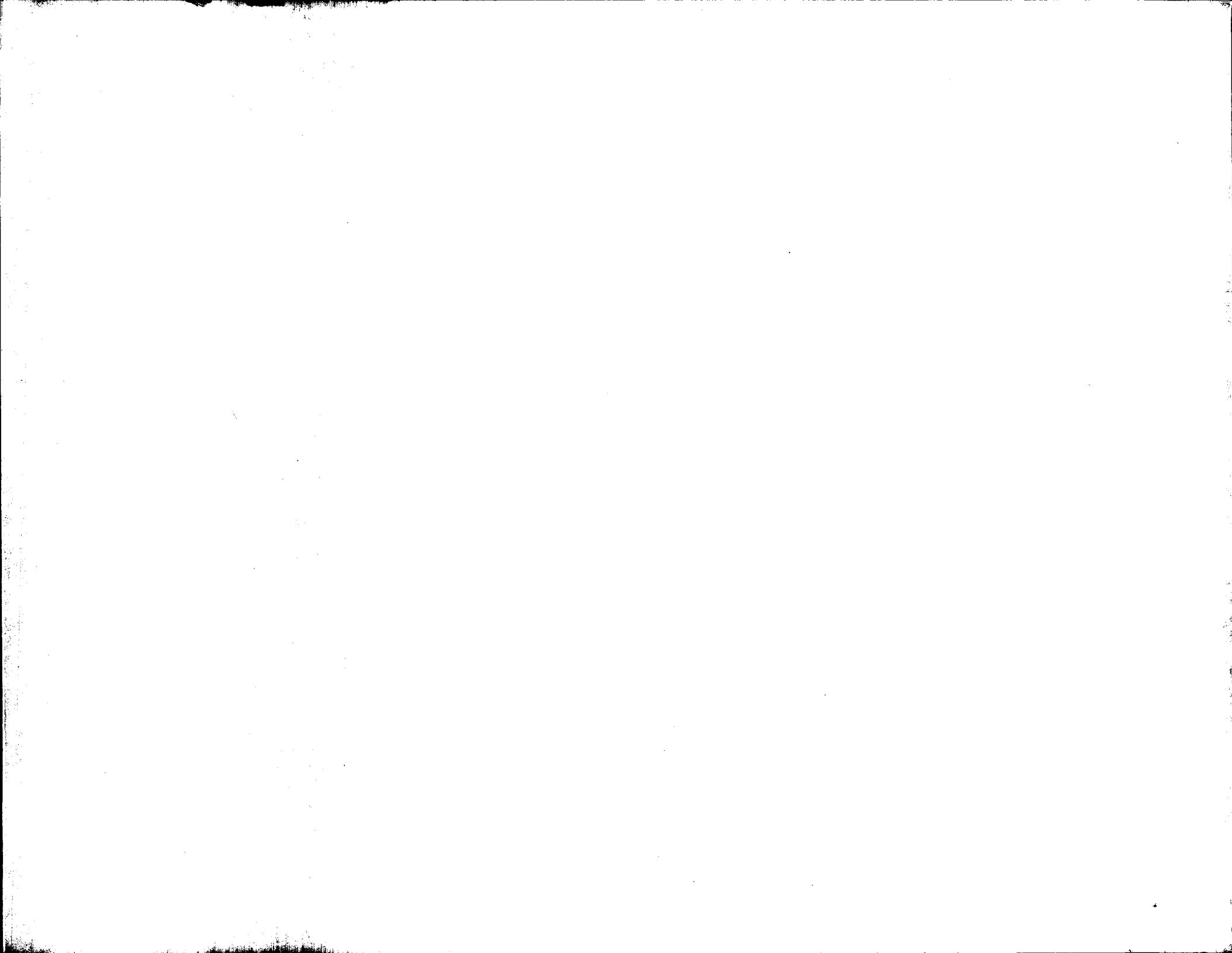
We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig (Regula) Walz".

Vankleek Hill, February 3, 2006

A handwritten signature in black ink, appearing to read "U6 02-17".





P.O. Box 781
Tel. 613) 678-3957 & 678-2782

20 Terry Fox Drive
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0
metec@metec.ca / www.metec.ca

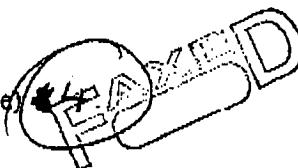
Fax cover page

Vankleek Hill, February 15, 2006

to Linda Lacelle
Dart

from Shigi Walz

Pages (incl. coverpage)



Hi Linda,

Please find attached the delivery slip for the lugs Marcus delivered this morning. Included ^{are} is also the Certificates of Conformity for this delivery as well as for the delivery from February 3, 2006.

Thanks a lot!

Shigi Walz

2nd attempt

Only received (3pages, coverpage ? 2 cents)
- 2 Certificates of Conformity



Tel. 613) 678-3957 & 678-2782

20 TERRY FOX DRIVE
Fax (613) 678-3956

Dolly

Vankleek Hill, Ontario, K0B 1R0
metec@metec.ca / www.metec.ca

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
203	D2230-1	Mounting Lug

MATERIAL: supplied by DART

<u>P.O. NUMBER</u>
446

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, February 15, 2006

A handwritten signature in black ink, appearing to read "Shigi (Regula) Walz". Below the signature, the date "06.02.06" is handwritten.

